



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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RBE350A93-3717-00
Job Sheet 194434



Part No: RBE350A93-3717-00

Job Qty: 2 pcs

Part Name: Case Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 6/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *over 1539*

Note: DWG RBE350A93-3717-00 Rev.B IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	6/25/19		0.00	2.00	Small Fab - 1		<i>MCC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	6/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	6/25/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S192039



Part: RBE350A93-3717-00

Job No: 194434

Serial No/Batch: S192039

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/19/19

DAS
40
9-89

JUN 19 2019

DAS
28
9-89

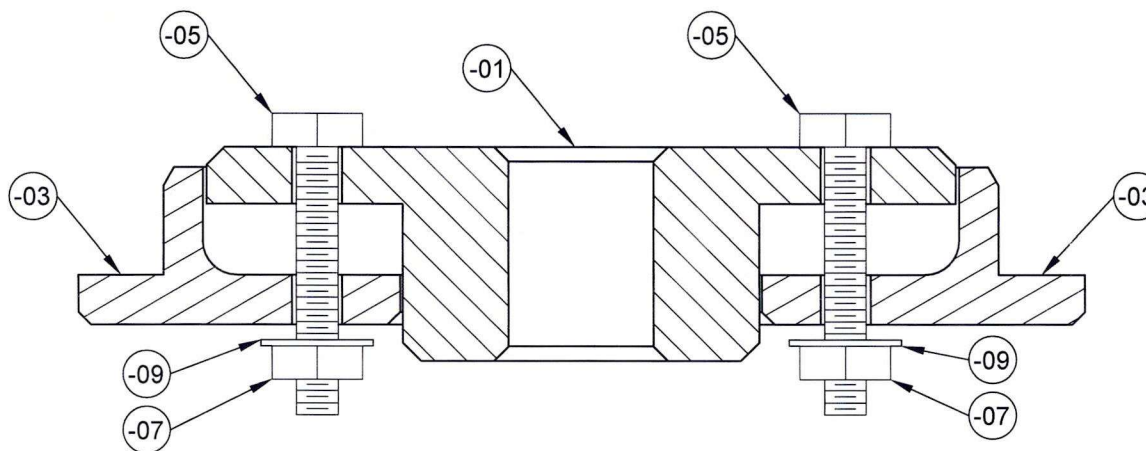
Plex 5/2/19 10:24 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	6/25/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 JUN 20 2019
				QC 21 - SA - 53	B-88
Part Op 110 - (Small Fab)1-Assemble as per DWG. Descriptions: 120 - QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location:_____) 140 - QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
90591A151	Nuts	4 Ea (2 ea)	110-Small Fab - 1	S122142	65
91280A334	Hex Head Cap Screw	4 Ea (2 ea)	110-Small Fab - 1	S122536	68
91455A120	Washer	4 Ea (2 ea)	110-Small Fab - 1	FM130544-6	50
RBE350A93-3717-00-01	Body	2 pcs (1 ea)	110-Small Fab - 1	S137502	143B
RBE350A93-3717-00-03	Half Receiver	4 pcs (2 ea)	110-Small Fab - 1	S144265 2X	143B
				S188560 2X	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	90591A151	4	98	0	
	91280A334	4	98	0	
	91455A120	4	96	0	
	RBE350A93-3717-00-01	2	2	0	
	RBE350A93-3717-00-03	4	2	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED MISSING DIMENSIONS -01 & -03 PER S.E.	11/30/10	RJC	
B	CH'D T/N WAS RBEA93-3717-00 IS RBE350A93-3717-00. -01 & -03 MOVED TO SEPARATE SHEETS, DELETED DUPLICATE DIMS, CH'D SPEC ON FINISH WAS MIL-C-81562B, TYPE II, CLASS I IS QQ-P-416F, TYPE II, CLASS I. -05 ADDED B/O INFO #91280A334. -07 ADDED B/O INFO #90591A151. -09 ADDED B/O INFO #91455A120. CH'D TOLERANCE ON NON-CRITICAL PARTS. -3 CH'D SPEC WAS Ø6 X 1-1/8 IS 1.0 X 4.5 X 5.50.	5/27/14	DPD	RJC

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194434 ML5
140502



NOTES:

1. TEST PIECES R.C. 5
2. "AMGC9927" WAS ALSO ENGRAVED ON TOOL.

RED BARN MACHINE	
TITLE CASE SEAL REPLACEMENT TOOL	
DWG NO. RBE350A93-3717-00	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED: <i>D. West</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 X 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER 350A
SCALE 1:1	DATE 8-13-09 SHEET 1 of 3

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	BODY	1018	Ø4-1/2 X 1-3/8	2
			-03	2	HALF RECEIVER	1018	1.0 X 4.5 X 5.5 (MAKES TWO HALVES)	3
		B/O	-05	2	HEX HEAD CAP SCREW	STEEL	M6x1 X 25mm MCMaster-CARR #91280A334	1
		B/O	-07	2	NUTS	STEEL	M6x1 MCMaster-CARR #90591A151	1
		B/O	-09	2	WASHERS	STEEL	Ø6mm MCMaster-CARR #91455A120	1
	ASSY #							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					